

Date: Thursday, 5/3/2007 11:35:48 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 412 X-TUBE INST, LOW NARROW AFT
Job Number : 32184	
Estimate Number : 12817	
P.O. Number : <i>N/A</i>	Part Number : D412664205
This Issue : 5/3/2007 S.O. No. : <i>N/A</i>	Drawing Number : D412-664 UNDER REV
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : <i>N/A</i>
Previous Run : 32183	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/15/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev. A New Issue 07-04-05 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-205 CHG001

*C2**KS 07.0530*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D412664245	CROSSTUBE ASSEMBLY, LOW NARROW AFT, 412C
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube 412 Low

Batch: *632211*

4.0	AN640A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: *M103446* ✓ *M19185* ✓

5.0	AN641A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: *M101428* ✓*7/6/21**S9*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 15 Date: 11/06/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:35:48 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE INST,LOW NARROW AFT

Job Number: 32184

Part Number: D412664205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M101660 ✓ ✓

7.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M103641 ✓ ✓

7/6/21 59

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

107/6/22 (1) C207/10/6/22 (1)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-105

Draft 7/16/22 (1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Done 10/6/22 (1)

Job Completion



332211

11 Oct 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

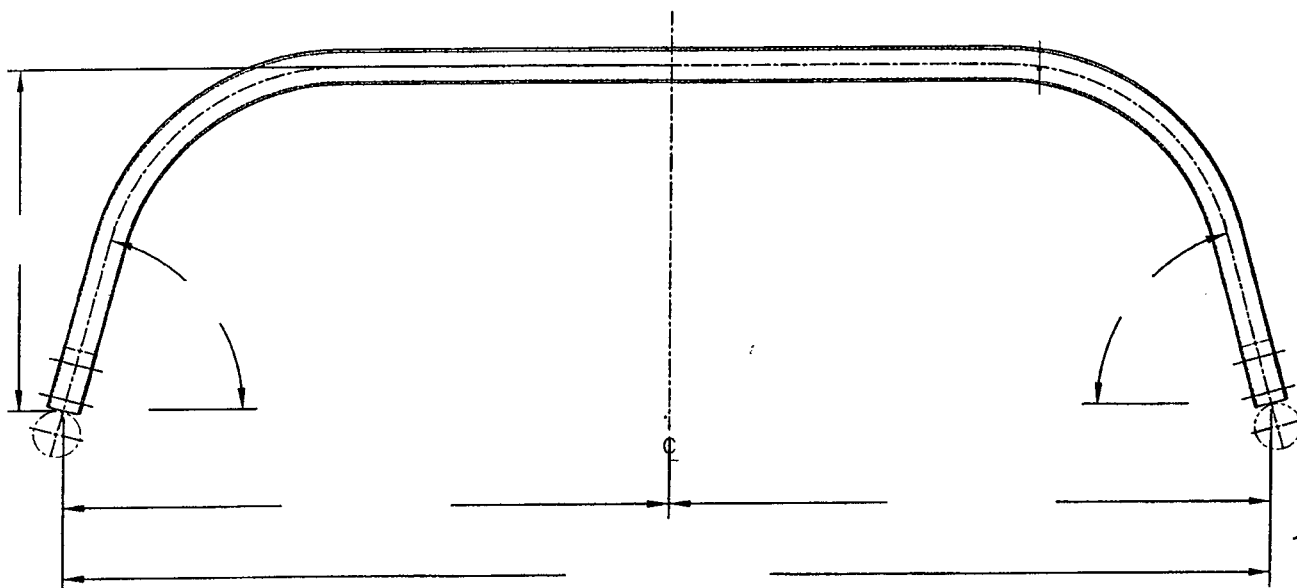
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	32184
<b>Description:</b> Crosstube Low Narrow Aft (412)		<b>Part Number:</b>	D412-664-205
<b>Inspection Dwg:</b> D412-664-245 <b>Rev:</b> C		<b>Page 1 of 1</b>	

Required Dimension	Min	Max
Height	16.69	16.95
1/2 Span	46.47	46.73
Angle	49°	52°
Total Span	92.94	93.46



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.04.27	New Issue	KJ/JM	<i>[Signature]</i>



DESIGN <i>QP</i>	DRAWN BY <i>QP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D412-664-245	REV. C SHEET 1 OF 3
DATE 07.03.29		TITLE CROSSTUBE ASS'Y (412 LOW-N AFT) NTS	
A	06.12.01	NEW ISSUE	
B	07.03.01	CHG CUFF AREA, CHG RUBBER CUSHION	
C	07.03.29	CHG RIVET AND RUBBER CUSHION	

RELEASED

07.04.24 *[Signature]*

**PARTS LIST:**

Qty	Part Number	Description
X	D412-664-245	CROSSTUBE ASSEMBLY (412 LOW-NARROW AFT)
1	D6009-129	CROSSTUBE
2	D2856-600-1009	ABRASION STRIP
1	D2896-1	SUPPORT
2	D3189-1	CHAFING SHIELD
2	D3595-063-570	RUBBER CUSHION
2	D3606-1	CUFF
44	CR3212-4-07	RIVET (OR M7885/3-4-07)
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129  
FINISHED LENGTH = 123.59±0.020 (BEFORE BENDING/TRIMMING)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3606-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

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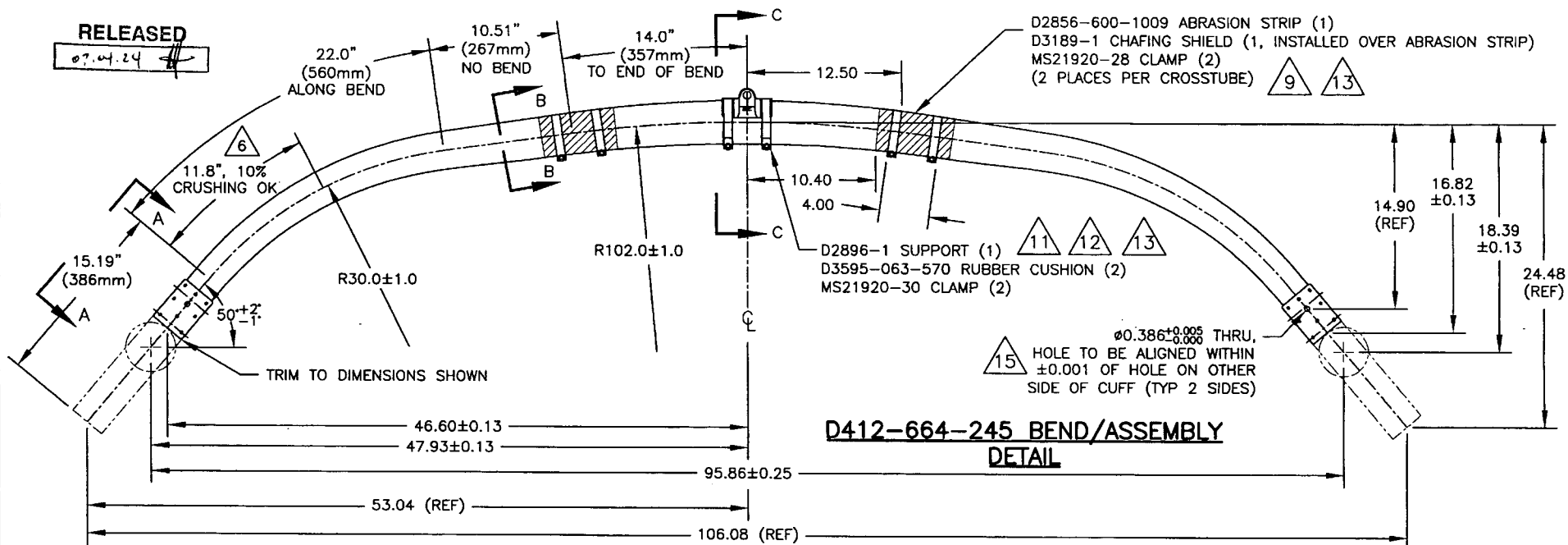
32184

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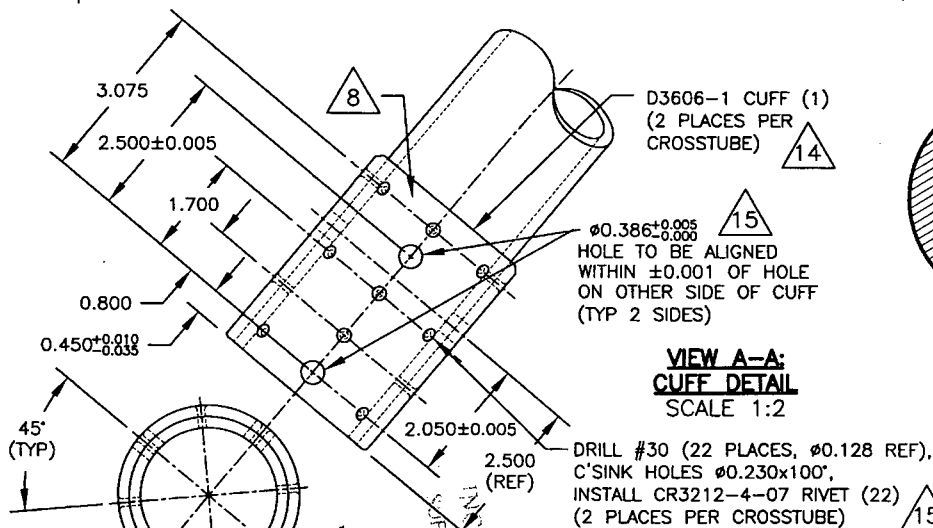
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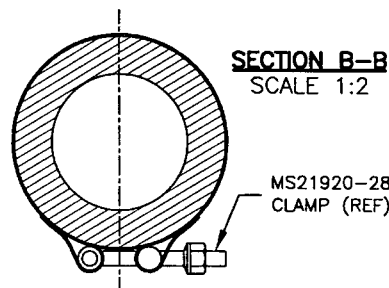
07.04.24



### D412-664-245 BEND/ASSEMBLY DETAIL



### VIEW A-A: CUFF DETAIL SCALE 1:2



### SECTION B-B SCALE 1:2

APPLY MAGNOBOND  
BETWEEN D2896-1 AND  
THE CROSSTUBE

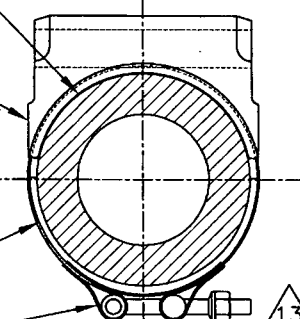


D2896-1  
SUPPORT  
(REF)

D3595-063-570  
RUBBER CUSHION  
(UNDER CLAMP, REF)

MS21920-30  
CLAMP (REF)

### SECTION C-C SCALE 1:2

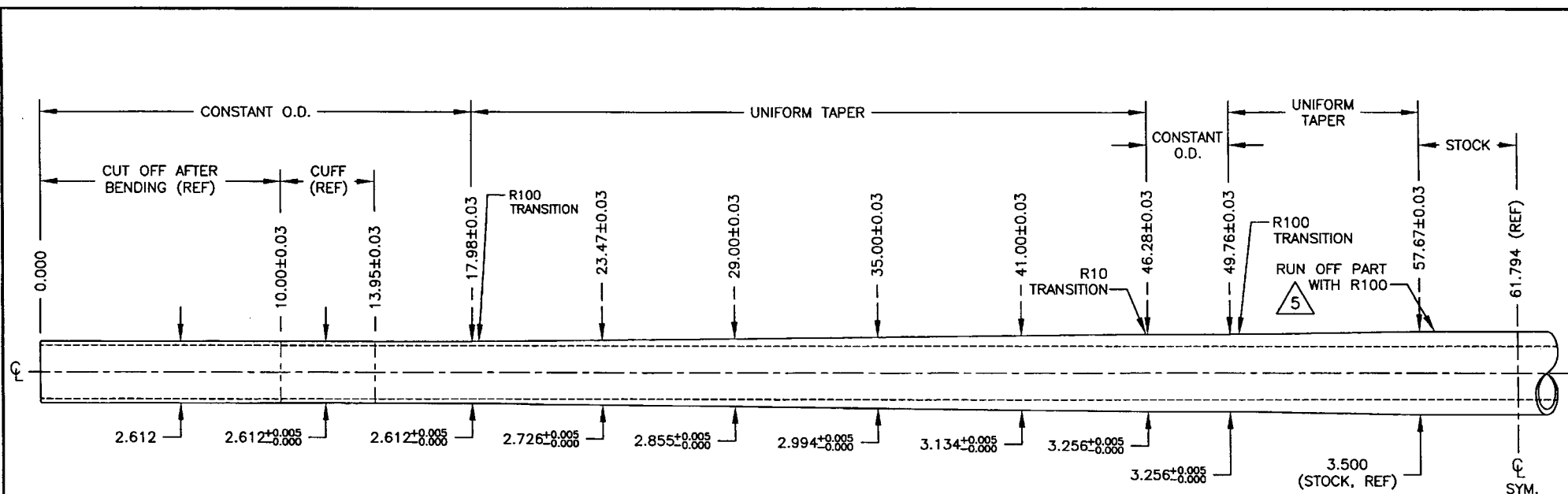


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CHECKED	07	APPROVED	07	DRAWING NO.	REV. C
DATE	07.03.29	TITLE	CROSSTUBE (412 LOW-NARROW AFT)	SHEET 2 OF 3	SCALE

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# **D412-664-245 MACHINING DETAIL**

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07.04.19

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		DATE		D412-664-245	SHEET 3 OF 3
		07.03.29		TITLE	SCALE
				CROSSTUBE (412 LOW-NARROW AFT)	1:4